



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D3391-023
Job Sheet 171997



Part No: D3391-023

Job Qty: 1 ea

Part Name: Mid Tube Assembly



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 2/12/18

Job Tracking No:

Due Date: 2/23/18

Created By: Michelle Gagnon-Donovan

Type: SOLD

Description:

Note: DWG REV J SHEET 7 IPP A 05.10.20 New Issue KJ/EC IPP B IPP C 07.03.20 rev F dwg EC IPP D 07.03.28 re-format EC IPP E 07.10.31 ecn 1053P EC IPP Rev:F ECN 1056 07-11-13 DD verified by: EC IPP Rev:G 08-09-08 new process (ecn 08-510) DD verified by:EC IPP Rev:H 08-09-10 revH as per dwg DD verified by:EC IPP Rev: I 08-11-13 Removed steps per w/o, QC KJ verified by: ec IPP Rev:J add in seq 140 expire date &b# sikaflex DD 10.02.17 verified by:EC

Ship Via:

Bill of Materials



Container No: S042334



Part: D3391-023

Serial No/Batch: S042334

Revision: D3391

Inspector:

Dart Aerospace Ltd.
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CANADA
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Date: 02/14/18 12:45 PM

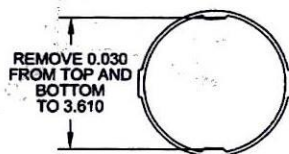
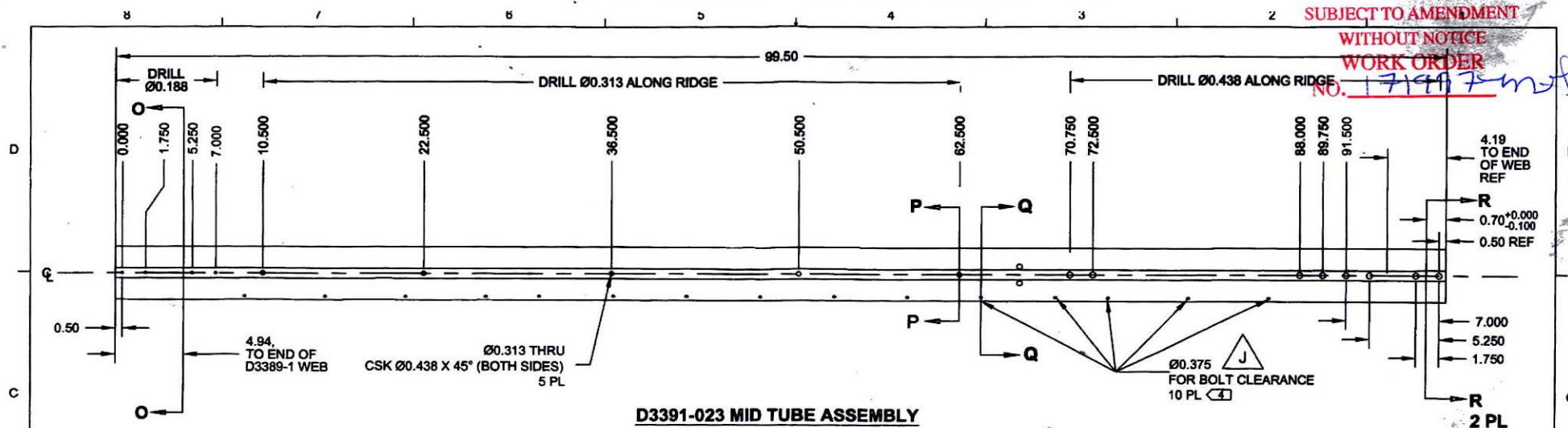
Plex 2/12/18 8:04 AM Dart, Gagnon, Michelle

Job Routing									
Op	No	Operation	Qty	Start Date	Due Date	Setup Run	Workcenter/Supplier		
							Standard	Workcenter/Supplier	Lead Time
90	Start up Operation	1 Ea	2/22/18	0.00	0.00	0.00	0.00	Start Up Skidubes-1	Sign-off
100	Skidubes	1 pcs	2/22/18	0.88	2.11	0.00	0.00	Skidubes-4	
110	QC	1 pcs	2/22/18	0.00	0.00	0.00	0.00	QC5	
120	HandFinish	1 pcs	2/22/18	0.00	0.38	0.00	0.00	HandFinish1	
130	QC	1 pcs	2/22/18	0.00	0.00	0.00	0.00	QC7-2	
140	Skidubes	1 pcs	2/22/18	0.00	2.11	0.00	0.00	Skidubes-4	
150	QC	1 pcs	2/22/18	0.00	0.00	0.00	0.00	QC5	
160	Skidubes	1 pcs	2/22/18	0.00	2.11	0.00	0.00	Skidubes-4	
170	QC	1 pcs	2/22/18	0.00	0.00	0.00	0.00	QC10	
180	QC	1 pcs	2/22/18	0.00	0.00	0.00	0.00	QC5	
185	HandFinish	1 pcs	2/22/18	0.00	0.38	0.00	0.00	HandFinish2	
191	SprayPaint	1 pcs	2/22/18	0.00	0.91	0.00	0.00	Spray Paint	
192	Outsource	1 pcs	2/22/18					ATE003-VC	
193	Packaging	1 pcs	2/22/18	0.00	0.00	0.00	0.00	Packaging2	
200	QC	1 pcs	2/22/18	0.00	0.00	0.00	0.00	QC14	
230	HandFinish	1 pcs	2/23/18	0.00	0.38	0.00	0.00	HandFinish4	
240	QC	1 pcs	2/23/18	0.00	0.00	0.00	0.00	QC5	
250	Packaging	1 pcs	2/23/18	0.00	0.00	0.00	0.00	Packaging3-1	
260	QC21-SA	1 Ea	2/23/18	0.00	0.00	0.00	0.00	QC21	
Part Op 100 - 1-Cut tube to finish length as per Dwg D3391 2-Drill pilot holes using D78796 (Do not drill "B" holes) and drill only 1									
Description: fwd saddle hole on one side only as per Dwg D3391 3-Open aft saddles and GHW holes to Ø0.4375" except for fwd saddle									
holes. Remove .030" from Fwd Indexing Ridge as per Dwg D3391 4-Remove Indexing ridge on Fwd & Aft end of									
skidube as per Dwg D3391 5-Deburr, scribe batch # on aft end. 7-Locate D3391-021 in D3391-023 at 9.00" (see view F-									
F) 8-Transfer drill one fwd saddle hole only to 1.88" dia hole, transfer drill all remaining fwd saddle holes using DT 8149									
location from previously drill 1.88" dia hole, using 1-pins and files to ensure perfect alignment, open up previously transfer									
drilled pilot holes in D3391-023/021 using drill press. ON FIRST SIDE ONLY drill out 2nd and forth fwd saddles holes to									
0.500" as per ON 2ND SIDE ONLY ream out 2nd and forth saddle hole to 0.499" D3391-021									
BATCH: 9-Drill #30 pilot holes using wearplate Jig DT8217 Identify Ø0.375" holes with paint marker,									
DO NOT DRILL HOLES #3-19-20 FROM FWD END OF JIG 10-Open wearplate holes of D3391-023 assembly detail									
section C-Q to Ø0.375" (10 holes) as per Dwg D3391 Open wearplate holes of D3391-023 assembly detail section H-H to									
Ø0.297" (20 holes) as per Dwg D3391 Deburr and blow out all chips from inside tube, scribe									
140 - 1-Open float bag holes as per dwg 2-C-sink float bag holes as per dwg 3-Prepare tube for welding 4-Bond web in									
place as per Dwg D3391 & QSI 015. Adhere for 12 hours) A/R Sikaflex exp: 18-01-21 18-01-21 18-01-21 18-01-21									
160 - 1-Weld crossbolt spacer as per dwg D3391 & QSI 004 2-grind weld flush									
185 - Re-alodine									
191 - PRIME AS PER DWG AND QSI005 4.2.1.3.3 PRIMER BATCH: 137670 PAINT AS PER DWG AND									
QSI005 4.2.2.4 PAINT: 137670									
230 - 1-Install Inserts as per Dwg									
Job BOM									
Part / Item									
Component Name									
Quantity									
Operation									
Container									
D2500-1-100	Skidube Extrusion	1 Ea (1 ea)	90-Start up Operation	230-HandFinish	5067279	5026944			
D3389-1	Web	1 Ea (1 ea)	140-Skidubes						
D3681-1	Spacer	5 Ea (5 ea)	160-Skidubes						
ALSA-1032-130	Rivnut	20 Ea (20 ea)	230-HandFinish						
D3591-1	Bushing	2 Ea (2 ea)	230-HandFinish						
Job Allocations									
Component Part									
Required									
Inventory									
Allocated									
90-Start up Operation	D2500-1-100	1	70	0					
140-Skidubes	D3389-1	1	9	0					
160-Skidubes	D3681-1	5	381	0					
230-HandFinish	ALSA-1032-130	20	8,687	0					
230-HandFinish	D3591-1	2	75	0					
Part Specifications									
Specifications could not be found.									

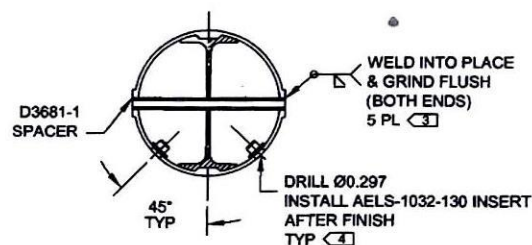
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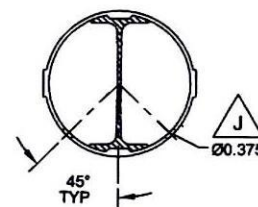
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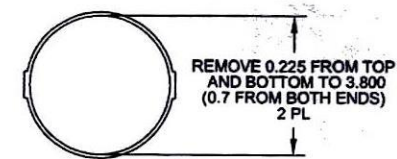
SECTION O-O
SCALE 2X



SECTION P-P
SCALE 2X



SECTION Q-Q
SCALE 2X



SECTION R-R
SCALE 2X

D3391-023 MID TUBE ASSEMBLY PARTS LIST

QTY	PART NUMBER	DESCRIPTION
X	D3391-023	MID TUBE ASSEMBLY
1	D2500-1-100	EXTRUSION
1	D3389-1	WEB
5	D3681-1	SPACER
20	AELS-1032-130	INSERT



D3391-023 MID TUBE ASSEMBLY

- 1) MATERIAL: MAKE FROM D2500-1-100
- 2) INSTALL D3389-1 WEB TO OUTER TUBE USING SIKAFLEX-241/-291 PER QSI 015
- 3) WELDING: PER DART QSI 004
- 4) USE DART DRILL TEMPLATE DT8217 TO LOCATE AND DRILL 0.297 AND 0.375 HOLES FOR WEARSHOE INSERTS AND NUTPLATES. CBORE AS NOTED AND INSTALL INSERT/NUTPLATES EXCEPT WHERE INDICATED.

DESIGN	PH	DART AEROSPACE USA, INC	
DRAWN	ML	EUGENE, OR	
CHECKED	CP	DRAWING NO.	REV. J
MFG. APPR.	<i>CP</i>	D3391	SHEET 7 OF 11
APPROVED	<i>CP</i>	TITLE	SCALE
DE APPR. ®	<i>CP</i>	412 FLOAT SKIDTUBE	NTS
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